

Work Order ID 84040

Tuesday, May 01, 2012 1:02:29 PM

84040

Eagle

Page 1

Item ID: D212-725-1-175F

Revision ID:

Item Name: Pilon Web

Start Date: 5/1/2012 Start Qty: 2.00

Required Date: 5/4/2012 Req'd Qty: 2.00

Reference:

Flat ONLY Accept

N900040100Setup Start ***NS1***Stop ***NS2***

Cust Item ID:

Customer:

Approvals: Process Plan: UMFDate: 12-05-01

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D212-725-1

F

0.00

100

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: FProg Rev: F

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

B12-5-2

B12-5-2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 84040***84040***

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Tuesday, May 01, 2012 1:02:29 PM

Item ID: D212-725-1-175F

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Pilon Web

Start Date: 5/1/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 5/4/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

150

Chemical Conversion Coat per QSI005 4.1

0.00

150

HandFinish

Memo

0.00

Hand Finishing

160

QC3- Inspect Part Finish

0.00

160

QC

Memo

0.00

Quality Control

Sizelator

72

2 0 12-52

2X 0 M-L 12/05/02

W/O:		WORK ORDER CHANGES					
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Work Order ID 84040

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Item ID: D212-725-1-175F

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Pilon Web

Start Date: 5/1/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 5/4/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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170	Identify as per dwg & Stock Location: _____	0.00							
-----	---	------	--	--	--	--	--	--	--

170

Packaging

Memo

0.00

Packaging

180	QC21- Final Inspection - Work Order Release	0.00							
-----	---	------	--	--	--	--	--	--	--

180

QC

Memo

0.00

Quality Control

2/5/38

12/5/4
MF
12-05-03

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Tuesday, May 01, 2012 1:02:28 PM

Page 1

Work Order ID: 84040

Parent Item: D212-725-1-175F

Parent Item Name: Pilon Web

Start Date: 5/1/2012

Required Date: 5/4/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 10.07.19 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.025 ALUM SHEET .025		Purchased	No			100	sf	48.0000	0.941	1.9810526			

B12-5-2

Location

Loc Qty

Loc Code

MAT022

48

116076

48

103504

103504

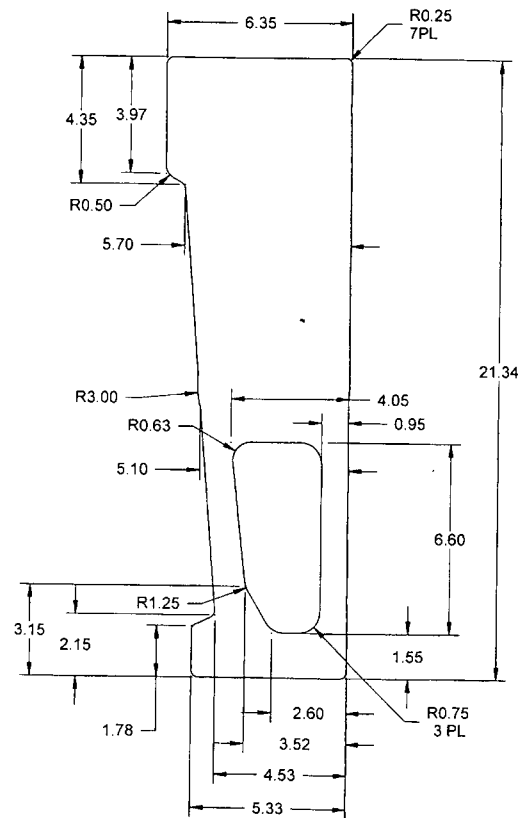
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D212-725-1-175F FLAT PATTERN





NOTES:

1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.025 THICK
PER QQ-A-250/4 OR AMS-QQ-A-250/4
OR AMS 4037
OR ASTM B209
REF DART SPEC. M2024T3S0.025

2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.244 lbs

#840410

RELEASED
2011-08-25
AWP

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4248	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		WEB	NTS
DATE	11.02.24	COPYRIGHT © 2011 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD			

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DART AEROSPACE LTD	Work Order: 84040
Description: Web	Part Number: D212-725-1-175F
Inspection Dwg: D212-725-1 Pg 59 of 84 Rev: F	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
6.35	+/-0.030	6.34	2		V B2	
21.34	+/-0.030	21.34	2		T B1	
0.95	+/-0.030	0.942	2		V	
6.60	+/-0.030	6.610	2		V	
1.55	+/-0.030	1.545	2		V	
4.05	+/-0.030	4.05	2		V	
2.60	+/-0.030	2.60	2		V	
3.52	+/-0.030	3.531	2		V	
4.53	+/-0.030	4.537	2		V	
5.33	+/-0.030	5.326	2		V	
1.78	+/-0.030	1.78	2		V	
2.15	+/-0.030	2.15	2		V	
3.97	+/-0.030	3.97	2		V	
4.35	+/-0.030	4.35	2		V	
0.025	+/-0.010	0.026	2		V	

Measured by: RB	Audited by: S	Preliminary Approval:
Date: 12-5-2	Date: 12/01/02	Date:

Rev	Date	Change	Revised by	Approved
A	11.01.20	New Issue	KJ	

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